

Work Order ID 78168

78168

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January-02-12 8:13:19 AM

Item ID: D3562-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly, LH

Start Date: 02/01/2012 Start Qty: 4.00

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/01/02

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	Rev E

100		0.00
100	Large Fab	
Large Fab	Memo	0.00
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Debur and bevel ends for welding	

(x5) 0

Ac 12.01.17

110	QC6- Inspect dimensions to drawing	0.00
110		
QC	Memo	0.00
Quality Control		

Pl 12.01.18

x5 0

120	Chemical Conversion Coat per QSI005 4.1	0.00
120		
HandFinish	Memo	0.00
Hand Finishing		

Pl 12.01.23

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 02/01/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject. Number	Insp. Stamp
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130 QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Transfer drill Rivet holes as per dwg D3562.
2-Touch-up rivet holes with alodine as per dwg d3562
3-Rivet legs using Magnabond as per dwg D3562.
*****Ensure to wipe off any excess magnabond *****
A/R Magnabond 6398 Batch: 117870

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop · ***NS2***

Start Date: 02/01/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00

160

Large Fab

0.00

Large Fab

Memo

1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

2-Grind end cap welds flush as per Dwg D3562

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

0.00

OC

Memo

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, LH
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	Chemical Conversion Coat per QSI005 4.1	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing									

5 BL 12-2-8

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
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200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>2:30</u>								
	OVEN TEMPERATURE: <u>320°F</u>								
	FINISH TIME: <u>3:00</u>								

210	Wing Walk as per dwg QSI005 4.4 Batch <u>120125</u>	0.00							
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210									
HandFinish	Memo	0.00							
Hand Finishing									

5X M-L 12/02/08
PB

5 BL 12-2-8

M 119480

W/O: 78168		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-041 PAR #: _____ Fault Category: Finish / Large FAB NCR: Yes No DQA: Not Date: 12/2/17
12-123 Resolution: Re work Disposition: Re work QA: N/C Closed: OK Date: 12/2/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/08	#200	Qty 22 steps have the residue from the magnabond coming through the P/C. it has turned the P/C brown/yellow and not give it a B&W	S 12/02/08	Scuff area and remove as much of the P/C as possible clean with thinner.	M-K 12/02/08	S 12/02/08	S 12/02/08	S 12/02/08
		Finish. P.C.	S 12/02/08	Re Powder coat as per QZ 005. Start 2-30 temp 3200 F Fin 3-00	M-K 12/02/08	S 12/02/08	S 12/02/08	S 12/02/08

NOTE: Date & initial all entries

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Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, LH
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
230									
Packaging	Memo	0.00							
Packaging	<u>W/O 78165</u>								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

EP 12/02/13 (5)

EP 12/02/13 (5)

12/2/15
W 12.02.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78168

78168

Parent Item: D3562-041

D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by:ec
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	86.0200	1	4			

D2622-120C

Step Extrusion

**

Ac 12.01.07

Location	Loc Qty	Loc Code
HALL	17.02	
46910	2	
64409	6	
66970	7.7	
68293	0.5	
72131	0.82	
WA013	69	
<u>75781</u>	69	

D2734

Manufactured No

140 Each

144.0000

2

**

(x5)

12.02.07

D2734

Step End Plate

Location	Loc Qty	Loc Code
WA	135	
<u>76985</u>	135	
WA015	9	
73416	9	

D3560-041

Manufactured No

140 Each

1.0000

1

4

**

12.02.07

D3560-041

Arm Weldment

Location	Loc Qty	Loc Code
WA013 <u>B79076 = 1</u>	1	
74803	1	
<u>B78170 = 3</u>	3	

*1
1
3*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 78168

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Parent Item: D3562-041

D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

D3560-043

Manufactured No

Each

0.0000

1

4

D3560-043

Arm Weldment

MS20600-AD4W5

Purchased

No

160

Each

487.0000

32

128

MS20600-AD4W5

Blind Rivet

Location

Loc Qty

Loc Code

ST321

B116289

481

114382

173

117505

82

118384

226

WA018

6

111477

6

**

**

12.02.01

12

83

77

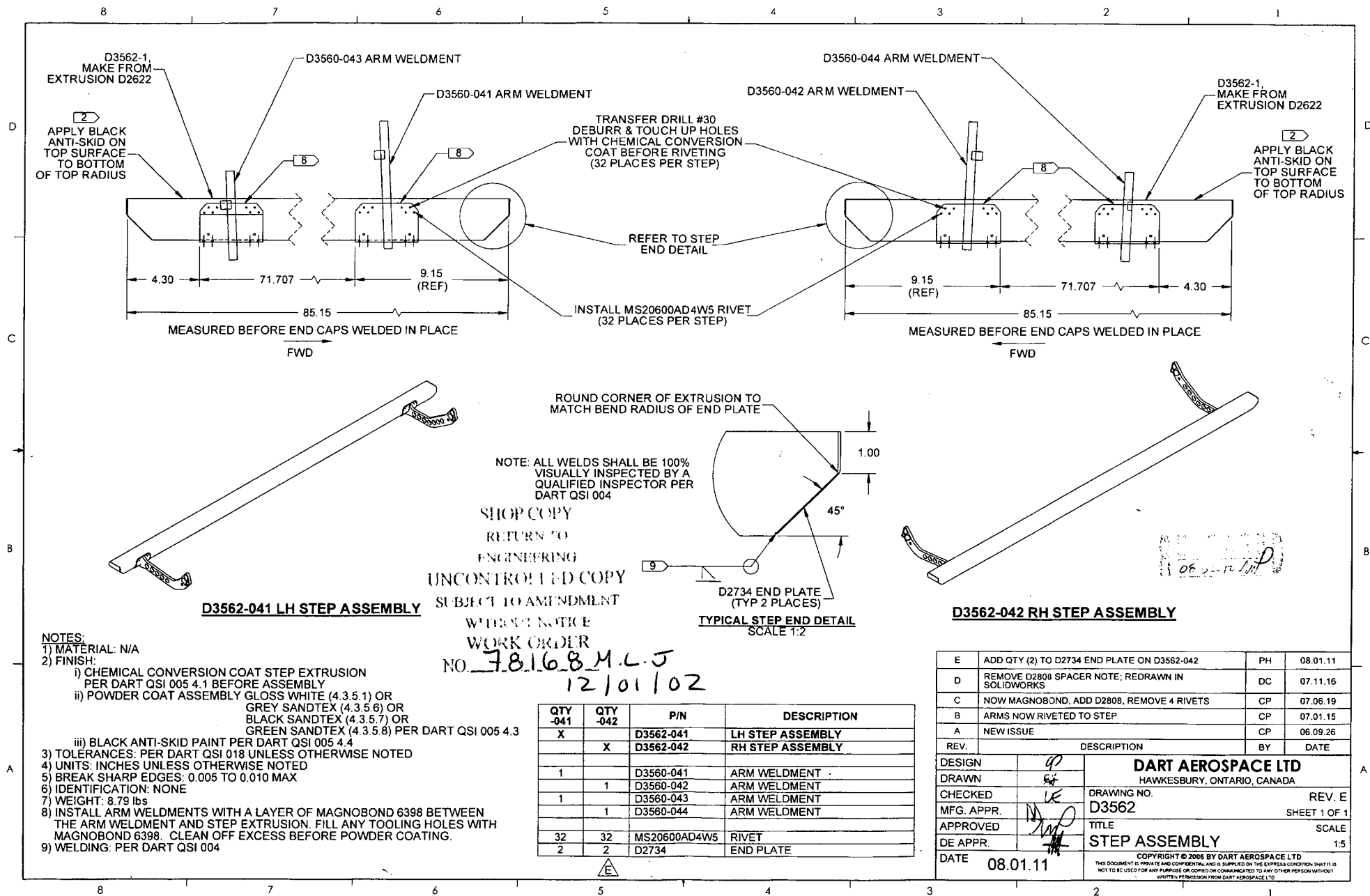
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